

Work Order ID 84842

May-24-12 7:58:09 AM

84842

Page 1

Item ID: D2724-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: 206L Step Assembly

Stop

NS2

Start Date: 24/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/28

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2724

Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2724-2 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding

2 0 12-01-05

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898
followed by Jig
A/R AL ROD Batch: 120854
Grind end cap welds flush 122130

2 0 12-07-09
Ae
12-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120									
QC	Memo	0.00				2	0	BE 12/6/12	
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

M/L
12/6/12
2X
RHx

W/O:		WORK ORDER CHANGES					
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Setup Start ***NS1***

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Stop ***NS2***

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Start Date: 24/05/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC3- Inspect Part Finish <i>QC7.</i> Memo	0.00 0.00				<u>2</u>	<u>0</u>	<u>BR 12-7-12</u>	
160 *160* Large Fab Large Fab	Large Fab Memo Inspect for foreign object per QSI 024 Weld Remainig end cap as per Dwg D2724 A/R AL ROD Batch: <u>120854</u> Grind end plate flush.	0.00 0.00				<u>2</u>	<u>0</u>	<u>12-07-13</u> <u>Ac</u> <u>12-07-16</u>	
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							

DAS
16
9-83

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: 206L Step Assembly

Stop ***NS2***

Start Date: 24/05/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		DAS 15 12-08 12/07/17		X2 RH			
190 *190* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2	76	12-7-17	
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 9:30 OVEN TEMPERATURE: 320°F FINISH TIME: 10:00	0.00 0.00				2X			MZ 12/07/17 RH

M121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 24/05/2012 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool

Plan
Code

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

220

Wing Walk as per dwg QSI005 4.4 Batch (M17) 5050.00

220

HandFinish

Memo

0.00

Hand Finishing

230

QC3- Inspect Part Finish

0.00

230

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: 206L Step Assembly

Stop ***NS2***

Start Date: 24/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240

Identify as per dwg & Stock Location: _____

0.00

240

Packaging

Memo

P178429

0.00

Packaging

12/2/19 @

250

QC21- Final Inspection - Work Order Release

0.00

250

QC

Memo

0.00

Quality Control

12/7/20 JF

JNF
12-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-24-12 7:58:13 AM

Page 1

Work Order ID: 84842

84842

Parent Item: D2724-042

D2724-042

Parent Item Name: 206L Step Assembly

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2734		Manufactured	No			110	Each	51.0000	1	2			
D2734									**			12.07.05	
Step End Plate													

Location	Loc Qty	Loc Code
WA <u>884563</u>	51	
76985	5	
80682	16	
83322	30	

D3458-1		Manufactured	No			110	Each	19.0000	2	4			
D3458-1									**			12.07.05	
Step Mounting Plate													

Location	Loc Qty	Loc Code
WA	16	
<u>82117</u>	16	
WA002	2	
75609	2	
WA018	1	
63075	1	

D3458-3		Manufactured	No			110	Each	29.0000	2	4			
D3458-3									**			12.07.05	
Step Mounting Plate													

Location	Loc Qty	Loc Code
WA	24	
<u>82116</u>	24	
WA002	5	
75610	5	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

May-24-12 7:58:13 AM

Page 2

Work Order ID: 84842

84842

Parent Item: D2724-042

D2724-042

Parent Item Name: 206L Step Assembly

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 2.00

Required Qty: 2.00

D2734

Manufactured No

160

Each

51.0000

1

2

D2734

**

Step End Plate

12.07.13

Location

Loc Qty

Loc Code

WA

384563

51

76985

5

80682

16

83322

30

2

D2622-120C

Manufactured No

100

Each

30.6100

1

2

D2622-120C

**

Step Extrusion

12.01.05

Location

Loc Qty

Loc Code

HALL

383894

16.37

46910

2

64409

6

66970

7.7

68293

0.25

72131

0.42

WA

4.88

81507

4.88

WA013

9.36

75781

2

77612

7.36

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

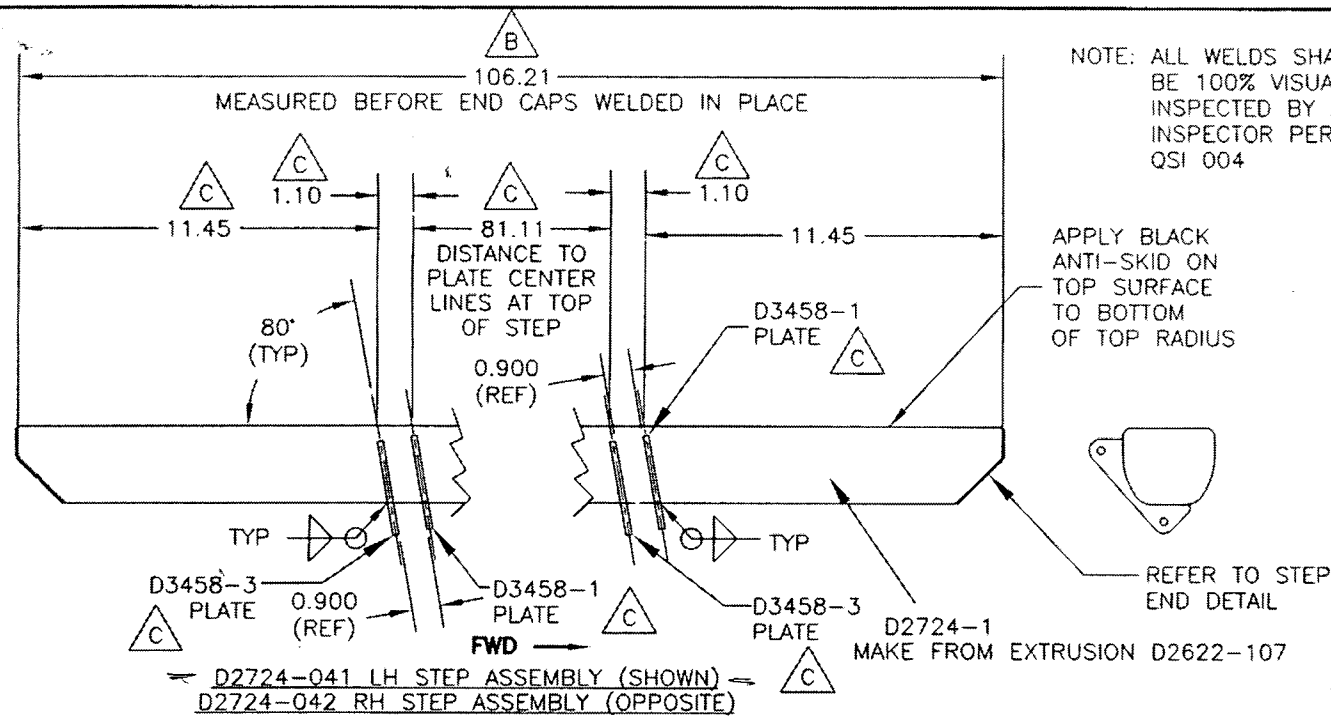
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART

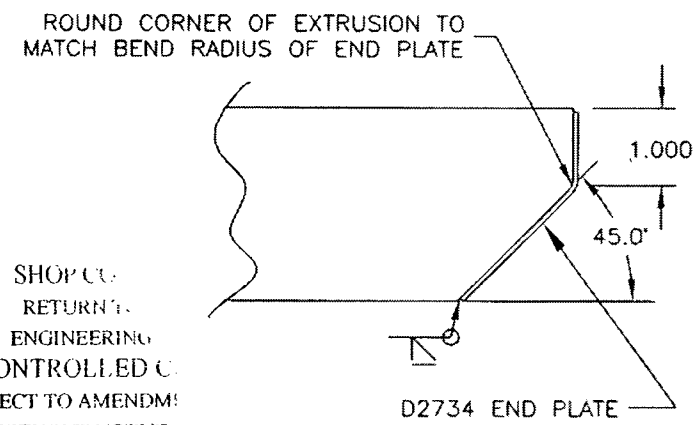
RELEASED
05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE



SHOP CO.
RETURN TO
ENGINEERING
UNCONTROLLED C
SUBJECT TO AMENDM

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WITHOUT NOTICE
WORK ORDER
NO. 84842 MLJ 12/05/28
TYPICAL STEP END DETAIL
NOT TO SCALE

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19			
	A	97.12.04		NEW ISSUE
	B	98.10.19		UPDATED WELD DETAIL REVISED TOLERANCES
	C	05.09.19		RE-DESIGN, ADD D3458-1/-3
				206L/407 STEP ASSEMBLY
				SCALE NTS
				SHEET 1 OF 1
				REV. C

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